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- (71) Applicants and
(72) Inventors: PESOVIC, Predrag [YU/YU]; Dantova 50, YU-11000 Beograd (YU). PESOVIC, Vojin [YU/YU]; Dantova 50, YU-11000 Beograd (YU).
- (74) Agent: MANIGODIC, Milenko; Kumanovska 2b, YU-11000 Beograd (YU).
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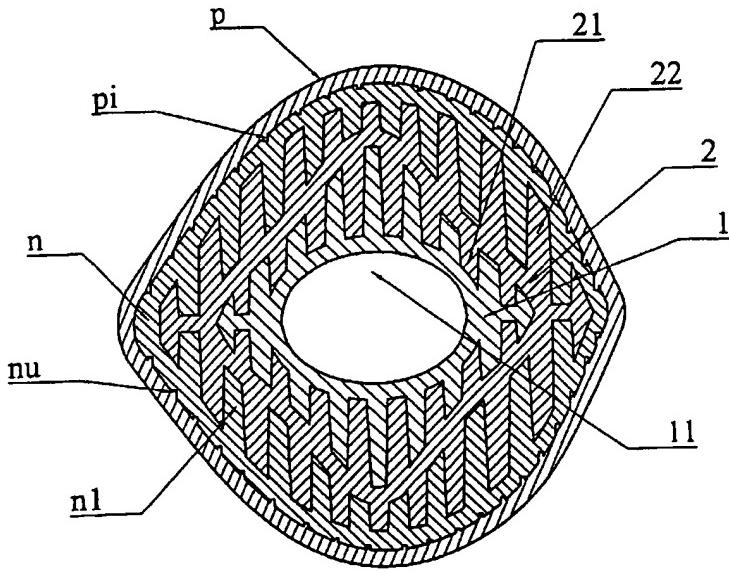
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(54) Title: METHOD FOR INJECTION MOLDING MULTI-LAYER PLASTIC PRODUCTS AND MULTI-LAYER PLASTIC PRODUCTS THEREOF

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desired layer (n) is injection molded whose ribs (n1) fill in the cavities or indentations of the previous layer, while on the surface of the layer (n) grooves (nu) are formed. The layer (n), which contains all the previous layers, is positioned in the last mold where the covering/finishing thin layer (p) is injection molded, whose ridges (pi) fill-in the grooves (nu) of the layer (n), while the outer surface of the layer (p), i.e. of the product, is smooth, or coarse if necessary, or profiled in a desired pattern or design.

(57) Abstract: The invention refers to the construction and the procedure for injection molding multi-layer plastic products. The procedure is to first injection mold the first layer (1) with ribbed protrusions (12). In the closed product structure, the segments (1', 1'') of the first layer (1), with an opening (11) shaped with a solid core or in any other known way, are joined into a skeleton via inlets (13), with coupling or in any other known way. First formed layer (1) is then precisely positioned into the next mold, and over the whole, or a part of the outer surface another layer (2) is injection molded, whose opposite ribs (21) fill in the cavities between the ribs (12), and the ribs (22) now protrude out of the surface of layer (2). Layer (1) over-molded with by the layer (2) is then positioned into the next mold and the whole procedure is repeated until the